

Work Order ID 60191

Monday, June 28, 2010 3:18:29 PM

Page 1

Item ID: D2230-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Lug

Start Date: 6/28/2010 Start Qty: 160.00

Cust Item ID:

Required Date: 7/5/2010 Req'd Qty: 160.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date: 10-6-29

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2230

Rev F

100

0.00



BAND SAW

Bandsaw

Memo

0.00

DJP 10/07/06

Jeaspa Bandsaw

Cut D2423 extrusion to 0.82"
Batch: 45800

160

0

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

MW= 10/07/13

HAAS CNC vertical machine #1

1-Machine per folio FA927
FOLIO REV: AA
DWG REV: G
Check for crack while loading into the machine.
2- deburr

160

0

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____








NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Required Date: 7/5/2010	Req'd Qty: 160.00		Customer:		
Reference:					
Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____	Stop
					
					

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 <i>MUE</i> 10/09/13				160	0		
130  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 <i>ank</i> 10/07/19				160	0		
150  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 <i>sl</i> 10/07/19				X160	0		

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Required Date: 7/5/2010

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Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

160 BR 10-7-19

170

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 12:00

OVEN TEMPERATURE: 320°

FINISH TIME: 12:30

160 BR 10-7-19

180

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

=> 9/10/07/19 160 Q

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Page 4

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Setup

Start



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Stop



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Required Date: 7/5/2010 Req'd Qty: 160.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Identify as per dwg & Stock Location: 476

0.00



Packaging

Memo

0.00

Packaging

10-7-22

SP 1602

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/07/23

MF 10-7-22

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Picklist Print

Monday, June 28, 2010 3:18:33 PM

Page 1

Work Order ID: 60191

Parent Item: D2230-3

Parent Item Name: Lug



Start Date: 6/28/2010

Required Date: 7/5/2010

Start Qty: 160.00

Required Qty: 160.00

Comments: IPP ☐ D ☐ 00.05.18 ☐ Added inspection level 8, and removed P/O for powder coat ☐ EC
25 JLM VERIFIED BY:EC
☐ IPP REV :E NEW FOLIO # 10-05-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2423 Lug Extrusion		Manufactured	No			100	f	425.4002	0.0683	11.50316			

Location

Loc Qty

Loc Code

MAT06

425.4001895

43722

180

45800

245.400189

11.50316 DSA 10/6/07

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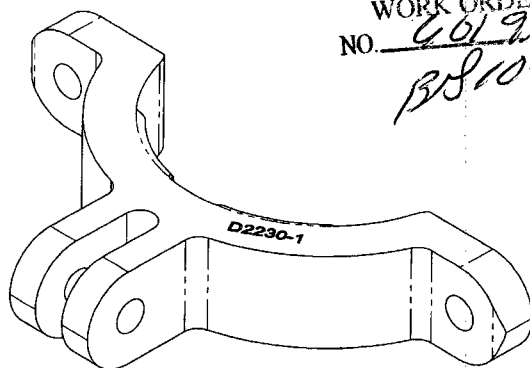
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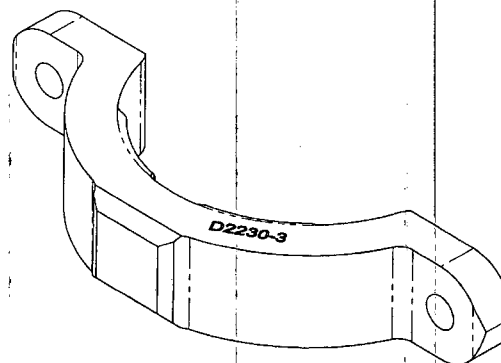
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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 60191
B810-6-29



D2230-1 MOUNTING LUG



D2230-3 MOUNTING LUG

RELEASED
01/06/25/00

REV.	DESCRIPTION	BY	DATE
G	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.	AJS	09.01.16
F	REDESIGN; R1.200 WAS 1.100	CP	99.12.13
E	RE-DESIGN	BW	95.01.04
D	RE-DESIGN	BW	95.01.04
C	RE-DESIGN	BW	94.03.30

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2230 TITLE MOUNTING LUG SCALE NTS
DRAWN	AJS	
CHECKED	<i>[Signature]</i>	
MFG. APPR.	<i>[Signature]</i>	
DE APPR.	<i>[Signature]</i>	
DATE	09.01.16	REV. G SHEET 1 OF 3

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NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005.
- 7) WEIGHT: -1: 0.16 lbs
-3: 0.14 lbs

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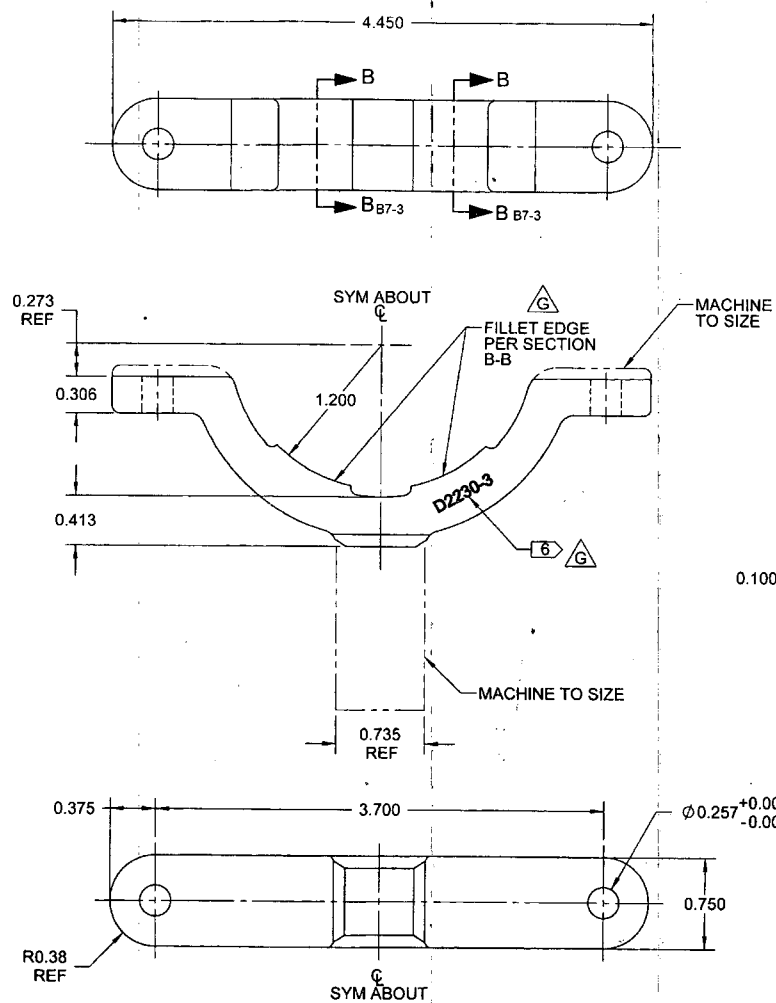
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SECTION B-B D4-3
SCALE 2X

R0.06 MIN - R0.10 MAX
2 PL



D2230-3 MOUNTING LUG

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
DATE	09.01.16	COPYRIGHT © 1984 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
09/06/2014

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